



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

20NR-04-1
Job Sheet 177411



Part No: 20NR-04-1

Job Qty: 4 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/10/18

Job Tracking No:

Due Date: 5/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-04 Rev 6 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/18/18	5/18/18	0.00	0.00	Start Up Machining-4		DAS 56 9-89
100	Mill Conv	4 pcs	5/18/18	5/18/18	0.50	0.80	Mill Conv 2		18/5/31
110	QC	4 pcs	5/18/18	5/18/18	0.00	0.00	QC2 Machining-5		18/06/06
120	QC	4 pcs	5/18/18	5/18/18	0.00	0.00	QC8 Machining-5		GA-Alain 18-06-06
130	Packaging	4 pcs	5/18/18	5/18/18	0.00	0.00	Packaging3-2		
140	QC21-SA	4 Ea	5/18/18	5/18/18	0.00	0.00	QC21		JUN 07 2018

Part Op 100 - 1- Jig in drawer 185 (DT10383) 2-Drill hole in shaft. Shaft should be retracted when drilled. Studs facing you rotate Descriptions: shaft clockwise to the end of stroke, push shaft into solenoid then drill as per DWG sheet 2 2-Engrave S/N and/or P/N number using Marktronic engraver as per DWG.
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
H-1127-020	Solenoid	4 Ea (1 ea)	90-Start up Operation	5070448

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	H-1127-020	4	0	0

Part Specifications

Specifications could not be found.



Container No: S076861



Part: 20NR-04-1

Job No: 177411

Serial No/Batch: S076861

Revision: 6

Inspector:

Exp Date: 05/31/2018

Instructions:

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Plex 5/10/18 1:58 PM Dart.lajeunesse.marie

Date: 05/31/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

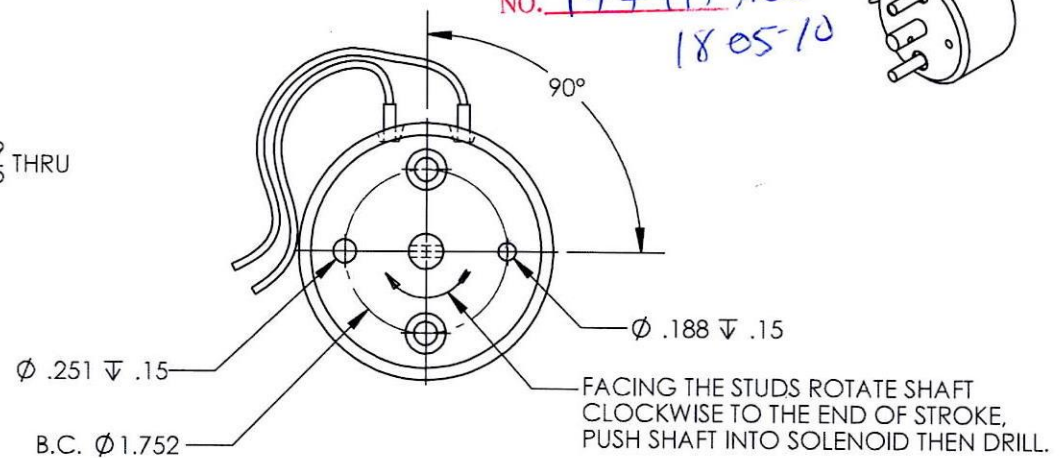
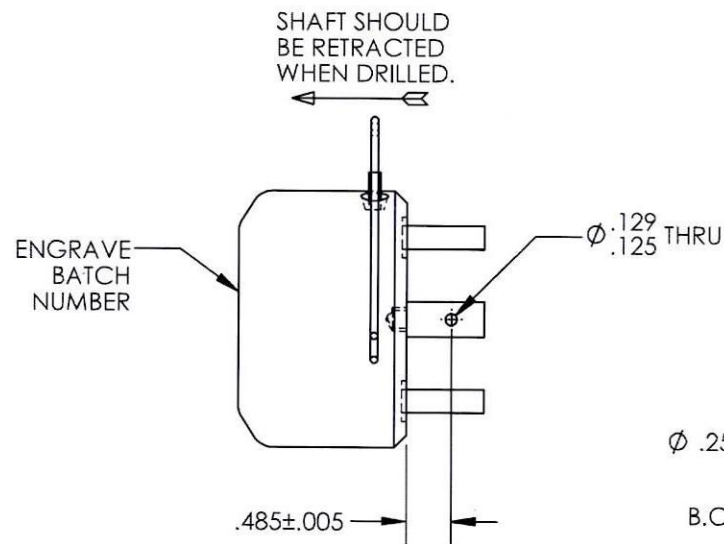
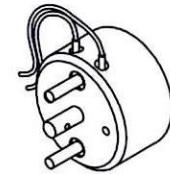
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	14-0206	20NR-04-1 ADDED ENGRAVE BATCH # NOTE.	11/3/2014	DPD	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 177411 1105
1805-10



20NR-04-1

SOLENOID

DART AEROSPACE	
TITLE SOLENOID	
DWG NO. 20NR-04-1	REV 6
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/1/1995
SHEET 2 OF 3	

1115 1200 120132